

Split SB 07/05/09

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: GUIDE ASS'Y	
Job Number	: 31913-2		Part Number	: D35725	
Estimate Number	: 12706		Drawing Number	: D3572 REV B	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 01/05/2007 S.O. No. : N/A		Drawing Revision	: B	
Prsh't Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 13/05/2007	
Previous Run	: 31913		Qty:	60	Um: Each
Written By	:		63		
Checked & Approved By	:				
Comment	: Est Rev :A New Issue 07-01-16 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	M6061T6S080	6061-T6 .080 Sheet
 Comment: Qty.: 0.0315 sf(s)/Unit Total: 1.8900 sf(s) 6061-T6 .080 Sheet Batch: M104186		
2.0	WATER JET	FLOW WATER JET
 Comment: FLOW WATER JET 1-Cut as per Dwg D3572 Dwg Rev: B Prog Rev: B		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
 Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK
 Comment: SECOND CHECK		
5.0	BRAKE NC	NC BRAKE
 Comment: NC BRAKE form bend as per Dwg D3572 usin DT8943		

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod. Mgr	Approval QC Inspector
07/05/09	5	split w/o			SB	07/05/09	34	07/05/10	07/05/10

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GUIDE ASS'Y

Job Number: 31913

Part Number: D35725

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Jan 05/10 (24)



Comment: INSPECT WORK TO CURRENT STEP

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: *ST108*

PO 7/10/11 (24)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



(24)

Comment: FINAL INSPECTION/W/O RELEASE

DAKHS115

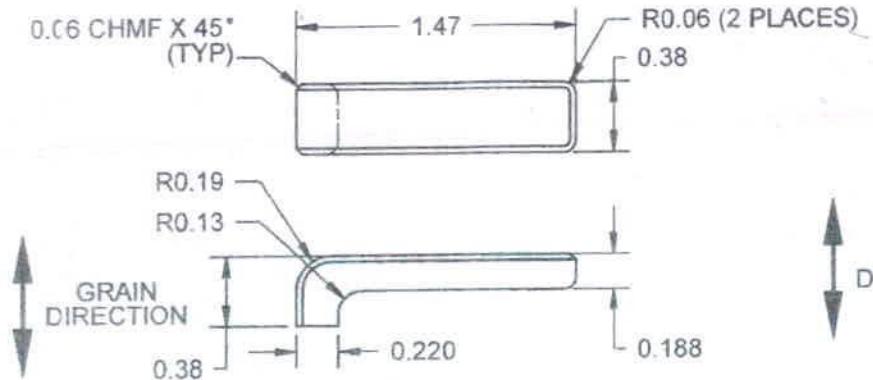
11/05/15

Job Completion



DART

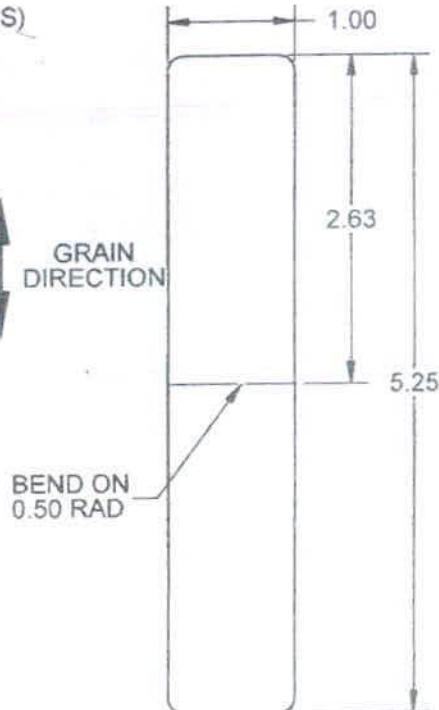
DESIGN <i>CE</i>	DRAWN BY <i>CE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>✓</i>	APPROVED <i>✓</i>	DRAWING NO. D3572	REV. A SHEET 2 OF 2
DATE 07.03.29	TITLE GUIDE ASSEMBLY	SCALE 2:3	



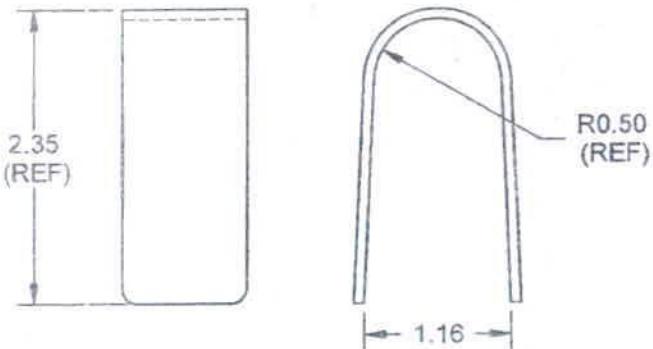
1 D3572-3 GUIDE

RELEASED

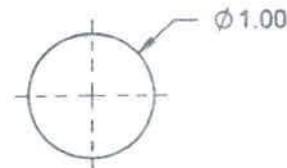
07.04.12 *✓*



2 D3572-5F FLAT PATTERN



D3572-5 BRACKET
(MAKE FROM D3572-5F)



2 D3572-7 CAP
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

D3572-3/5/7 NOTES:

- 1) D3572-3 MATERIAL: 6061-T6 (OR T651/T6510/T651/T62) ALUMINUM BAR PER QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 (OR AMS 4160) (REF DART SPEC M6061T6B)
- 2) D3572-5/7 MATERIAL: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK PER QQ-A-250/11 OR AMS 4025 OR 4027 (REF DART SPEC M6061T6S.080)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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Guide A5 '81

Part Number D357225

D3572 Rev B

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Spec	Tolerance	Actual	Accept	Reject	Method of Inspection
1.00	+0.030	1.01	✓		Var
5.25	+1.030	5.26	✓		Very
0.080	+1.010	0.036	✓		Very

674.7 Direction



SAD 09/05/84

Date: 09/05/84

Proto. Report: 09/05/84

Sign: MHA

Change

New Spec

